

5/46

DART AEROSPACE LTD	Work Order:	24678
Description: Bracket Assembly	Part Number:	D3121-043
		D3121-044 ✓
Dwg: D3121 Rev. C2 page 1, 3, 5	Qty:	4 Kits
D3121-043 replaces Premier P/N B30-23000-37		
D3121-044 replaces Premier P/N B30-23000-38		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Dwg not required	DJ	05.10.26	4
2	MV	Cut (1) blank per D3121-13 & (1) blank per D3121-14 Cut blanks (1.00" x 2.00") x 3.250" Long Bar Material: 17-4 SS per AMS 5604/5643 (M17-4-B1.000x02.000) Batch: <u>M14773</u>	J.L	05.11.14	8
3	MV	Machine D3121-13 as per Folio FA329 and Dwg D3121	J.L	05.11.17	4
4	QC2	Inspect parts as they come off the CNC machine	J.L	05.11.17	4
5	MV	Machine D3121-14 as per Folio FA329 and Dwg D3121	J.L	05.11.18	4
6	QC2	Inspect parts as they come off the CNC machine	J.L	05.11.18	4
7	MV	Deburr Break all sharp edges 0.005 to 0.015	J.L	05.11.18	4
8	MV	Scribe batch number to D3121-13 & D3121-14 at the back face.	J.L	05.11.18	8
9	QC5	Second check D3121-13 and D3121-14	ML	05.11.18	8
10	GA	Assemble D3121-043 as per Dwg D3121 Pick: Qty Part Number Description Batch 2 D3121-21 Bolt B24475B 2 D3121-241 Bearing Assembly B24777 Identify as D3121-043	BG	05.11.20	4
11	GA	Assemble D3121-044 as per Dwg D3121 Pick: Qty Part Number Description Batch 2 D3121-21 Bolt B24475B 2 D3121-241 Bearing Assembly B24777 Identify as D3121-044	BG	05.11.20	4+4
12	QC5	Inspect work to Step 10 & 11	BG	05.11.20	4+4
13	ST	Identify and Stock in Spacedoor cell D3121-043 Qty <u>4</u> D3121-044 Qty <u>4</u> Loc 400	62	05/11/21	4+4
14	AC	Parts to Stock and Prorate Cost to parts per Step 13 Cost / part: _____			
15	DC	Close W/O Inspect Level 21	DP	05/11/23	8

Rev	Date	Change	Revised By	Approved
A	02.05.21	New issue	NG	
B	03.05.02	Reformat	KJ/RF	
C	05.01.27	Revised Steps 10-11	KJ/JLM	

RELEASED
05/05/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 05/11/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	24678
Description: Bracket		Part Number:	D3121-13
Inspection Dwg: D3121 Rev: C2		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.300	+/-0.010	.302	✓			
0.080	+/-0.010	.081	✓			
0.392	+0.002/-0.000	.392	✓			
0.350	+/-0.010	.351	✓			
1.540	+/-0.010	1.540	✓			
R0.250	+/-0.010	.250	✓			
1.800	+/-0.010	1.801	✓			
1.370	+/-0.010					
1.050	+/-0.010					can't find dimensions
0.420	+/-0.010					
0.400	+/-0.010	.398	✓			
1.220	+/-0.010	1.219	✓			
2.63	+/-0.030	2.630	✓			
2.80	+/-0.030	2.801	✓			
2.48	+/-0.030	2.480	✓			
0.130	+/-0.010	.133	✓			
0.300	+/-0.010	.303	✓			
0.080	+/-0.010	.081	✓			
0.260	+/-0.010	.260	✓			
0.032	+/-0.010	.033	✓			
0.200	+/-0.010	.204	✓			
0.400	+/-0.010	.400	✓			
0.381	+/-0.010	.386	✓			

Measured by:	J.L	Audited by:	Ed	Prototype Approval:	N/A
Date:	05.11.17	Date:	05/11/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	<i>[Signature]</i>

RELEASED

05/05/2017

DART AEROSPACE LTD		Work Order:	24678
Description: Bracket		Part Number:	D3121-14
Inspection Dwg: D3121	Rev: C2	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.300	+/-0.010	.303	✓			
0.080	+/-0.010	.082	✓			
0.392	+0.002/-0.000	.3923	✓			
0.350	+/-0.010	.349	✓			
1.540	+/-0.010	1.540	✓			
R0.250	+/-0.010	.250	✓			
1.800	+/-0.010	1.801	✓			
1.370	+/-0.010					
1.050	+/-0.010					can't find dimension
0.420	+/-0.010					
0.400	+/-0.010	.398	✓			
1.220	+/-0.010	1.220	✓			
2.63	+/-0.030	2.629	✓			
2.80	+/-0.030	2.800	✓			
2.48	+/-0.030	2.479	✓			
0.130	+/-0.010	.134	✓			
0.300	+/-0.010	.301	✓			
0.080	+/-0.010	.078	✓			
0.260	+/-0.010	.260	✓			
0.032	+/-0.010	.032				
0.200	+/-0.010	.205	✓			
0.400	+/-0.010	.401	✓			
0.381	+/-0.010	.385	✓			

Measured by: J.L	Audited by: gml	Prototype Approval:	N/A
Date: 05.11.17	Date: 05.11.17	Date:	N/A

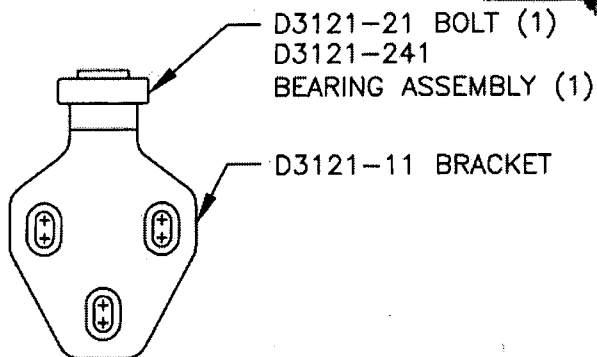
Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue P/O D3121-043/-044	KJ/JLM	

RELEASED
05.02.17

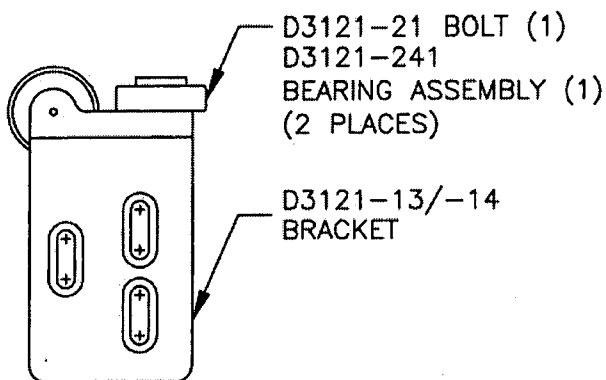


DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. C SHEET 1 OF 10
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:2
A	02.04.15	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146	
C	04.02.17	ADD CLEARANCE; USE -241 BEARING	
C1	04.03.26	B.17 WAS 4.00; 6.11 WAS 6.14	
C2	04.04.26	0.230 WAS 0.238	

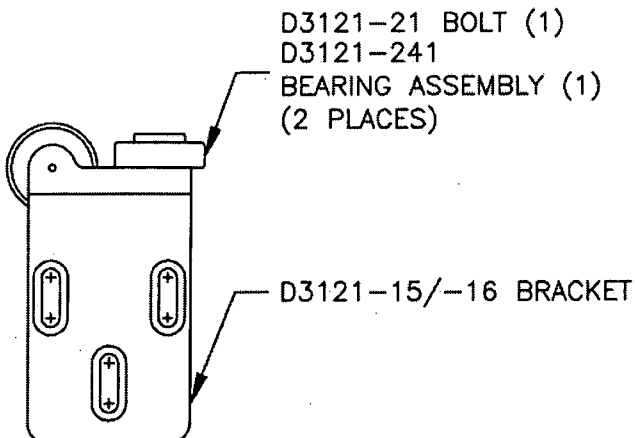
RELEASED
04.03.01



D3121-041 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-33)



**D3121-043 (SHOWN) / D3121-044 (OPPOSITE)
BRACKET ASSEMBLY**
(REPLACES PREMIER P/N B30-23000-37/-38)



**D3121-045 (SHOWN) / D3121-046 (OPPOSITE)
BRACKET ASSEMBLY**
(REPLACES PREMIER P/N B30-23000-35/-36)

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WORK ORDER
NO. 24678

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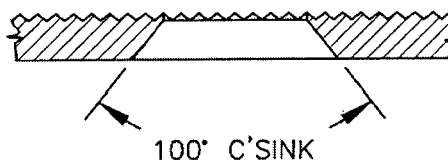
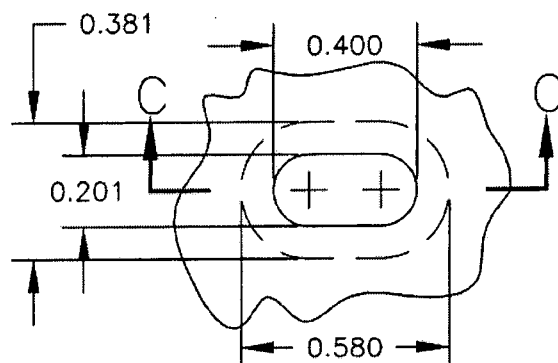
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DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. C SHEET 3 OF 10
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1

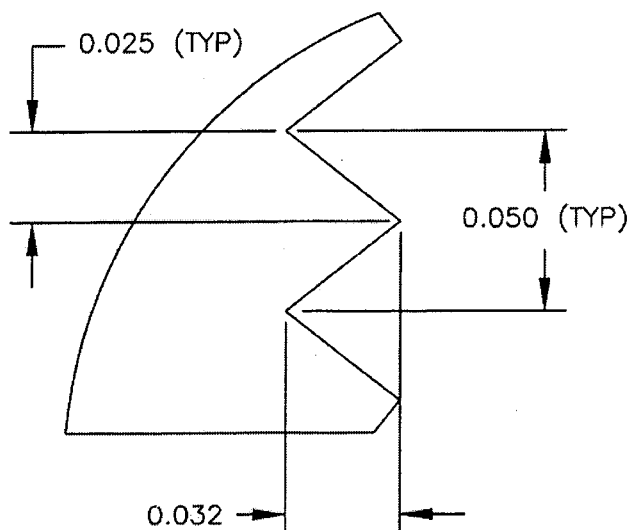
RELEASED
04.03.01 #

DETAIL A:
SLOT DETAIL
SCALE 2:1
VIEW ROTATED



SECTION
C-C

DETAIL B:
RIDGE DETAIL
PARTIAL SECTION
SCALE 1:20



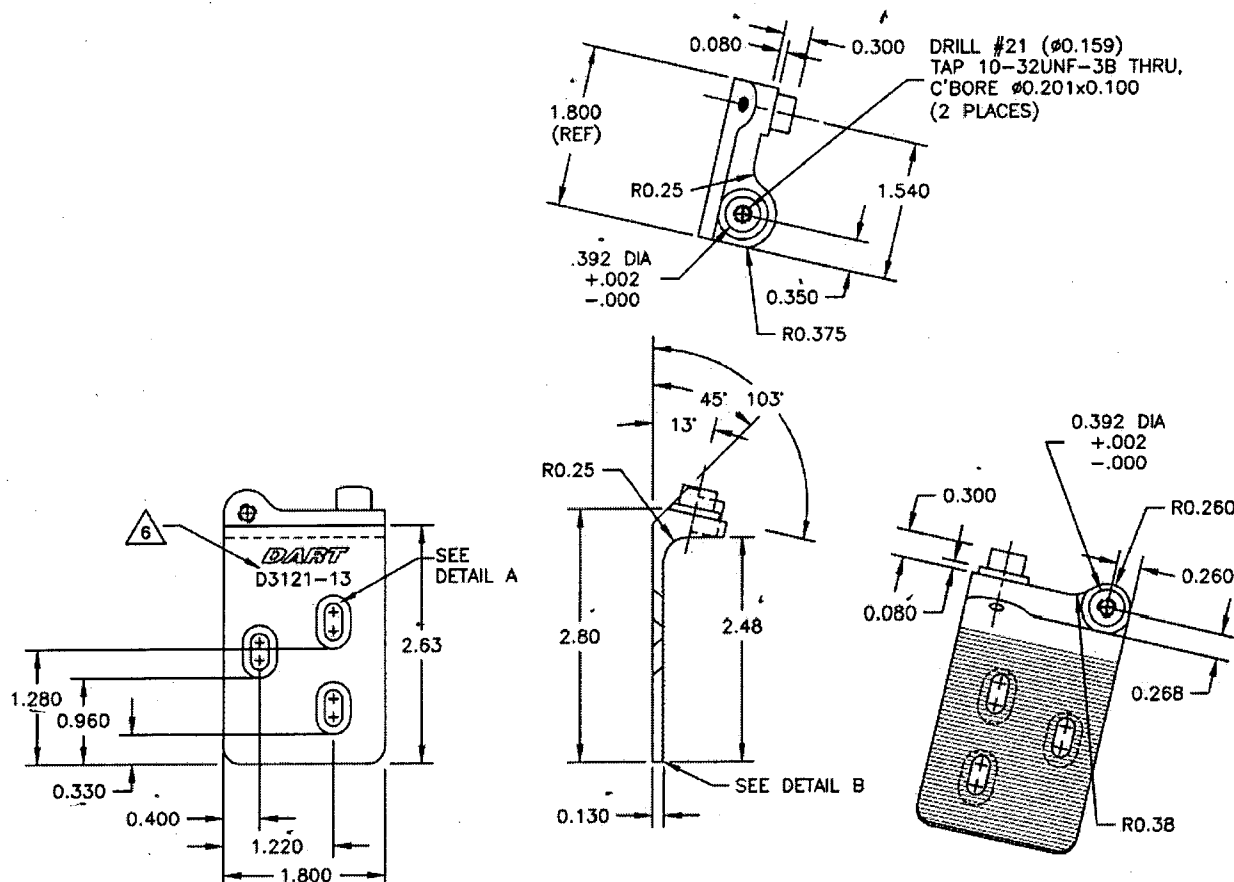
NO. 24678
WORK ORDER
SUBJECT TO
PROJECT 10
WITH 100%
ACCOUNT ROL
RETURN TO
ENGINEERING
NO. 24678

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DESIGN #	DRAWN BY P	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. C SHEET 5 OF 10
DATE 04.02.18		TITLE BRACKET ASSEMBLY	SCALE 1:2



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RETURN TO
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SUBJECT TO
WITHDRAWAL

D3121-13 BRACKET (SHOWN)
D3121-14 BRACKET (OPPOSITE)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B) WORK:
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

NO 24678

RELEASED
04.03.01

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 25, 2005
04:04 pm

Work Order No : 0024678
Project Name : D3121-044
Project For : WK546
Work Order Type : Main
Main WO Number :
House Part Number : D3121-044
Description : Bracket Assembly
Manufactured : Yes
Amount Req'd : 4
Amount Done : 0
Start Date : 10-25-05
Est Finish Date : 11-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00